

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023348**Date Inspected:** 08-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

4AE and 4BE (North Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Ribs total 39 nos. and only 35 been inspected except No. 1, 2, 4 and 23 for Segment 4AE to 4BE from PP 25 to PP 26. Inspected on 10% random basis found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M22x2.5x65 RC Set# DHGM220016 and final Torque required is 495 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 0830 Hrs.

4AE and 4BE (North Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs total 19 Nos. for Segment 4AE to 4BE from PP 26 to PP 27 Side Panel Lap Plates checked the gap by sliding 1mm thk. Steel ruler and found ruler is not sliding in. Inspected on 10% random basis found satisfactory and green tag not signed off as

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no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M22x2.5x65 RC Set# DHGM220016 and final Torque required is 495 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 1315 Hrs.

4AE and 4BE (North Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs total 19 Nos. for Segment 4AE to 4BE at PP 27 (Except 1(one) T-rib which is 6th T-rib from Corner Assembly and 14th from the Longitudinal Diaphragm due to offset) and at PP 28 Side Panel Lap Plates checked the gap by sliding 1mm thk. Steel ruler and found ruler is not sliding in. Inspected on 10% random basis found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M22x2.5x65 RC Set# DHGM220016 and final Torque required is 495 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 1315 Hrs.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
